

Fig. 1

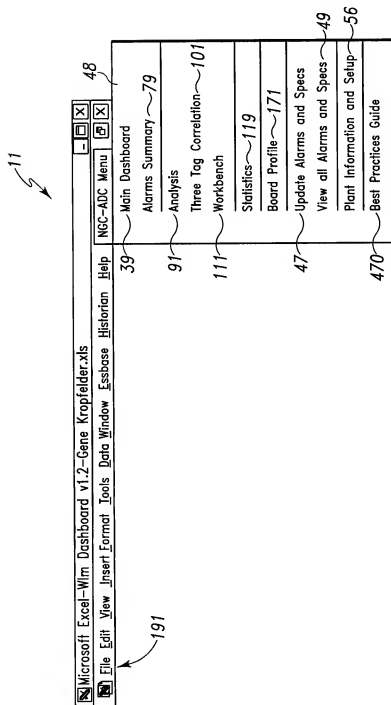


Fig. 2A

41

Fig. 2B

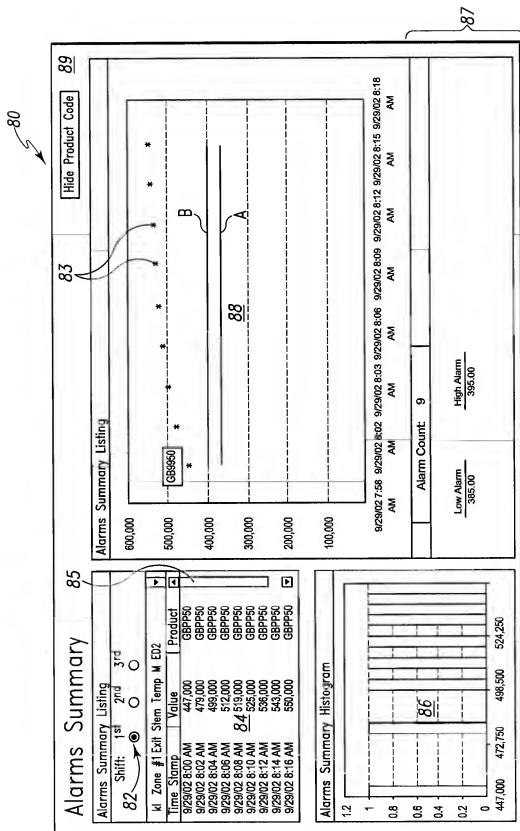


Fig. 3

435

Update Alarms and Specifications

UPDATE 54 ☐ Mill Data ☐ West End Feeds ☐ West End Tests

CANCEL ☐ Board Tests ☐ Kiln Temp/Most ☐ Free Tags

436 50 57

mil - calcine #6 Culfet Temp Actual

PLC Value	1	2	3	4	5	6	7	8	9	10	11	12	13
Product Description	All	1/2" Reg TE	1/2" HS TE (Smooth)	1/2" SS TE (Sta Smooth)	1/2" KK TE	1/2" db (Durand's)	1/2" PSE TE	1/2" PSE SS (Sta Smooth)	1/2" PSE KK	5/8" FS TE	5/8" FS KK	5/8" FS SS	
Product Code	All	GB4080	GB8019	GB8670	GB8116	GB2280	GB5926	GB6793	GB6601	GB8950	GB1280	GB1310	
High Alarm	370	370	370	370	370	370	370	370	370	370	370	370	
Low Alarm	330	330	330	330	330	330	330	330	330	330	330	330	
Upper Spec Limit	0	0	0	0	0	0	0	0	0	0	0	0	
Lower Spec Limit	0	0	0	0	0	0	0	0	0	0	0	0	

44

52

Fig. 4A

85

54

60

Product Information

62

PLC Value	Product Code	Description	Width (Inches)
0	NONE	NO PRODUCT RUNNING	NONE
1	GB4080	1/2" REG/TE	48
2	GB6019	1/2" HS TE	48
3	GB6270	1/2" SS TE (Sta-Smooth)	48
4	GB6016	1/2" SS HS (Sta-Smooth)	48
5	GB2280	1/2" KK TE	48
6	GB5926	1/2" DB (Dumbbese)	48
7	GB6793	1/2" FSC TE	48
8	GB6601	1/2" SS HS (Sta-Smooth)	48
9	GB6038	1/2" FSC KK	48
10	GB9950	5/8" FS TE	48
11	GB1280	5/8" FS TE	48
12	GB1310	5/8" FS SS	48
13			
14			
15			
16			
17			
18			
19			
20			
21			
22			
23			
24			

Shift Information

1st SHIFT	Starts At	Ends At
8:00 AM	4:00 PM	12:00 AM
2nd SHIFT	12:00 AM	8:00 AM

72

Dual Line Plant	Yes
Line Number	2

74

Plant Information

Line Length (dual to Knife) -Feet	595
Wet Transfer Length -Feet	30
Kiln Length -Feet	413
Number of Decks in Kiln	8
Kiln Zone 1 Length -Feet	121
Kiln Zone 2 Length -Feet	67
Kiln Zone 3 Length -Feet	205
Kiln Zone 4 Length -Feet	

76

68

64

66

70

Fig. 5

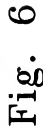


Fig. 6

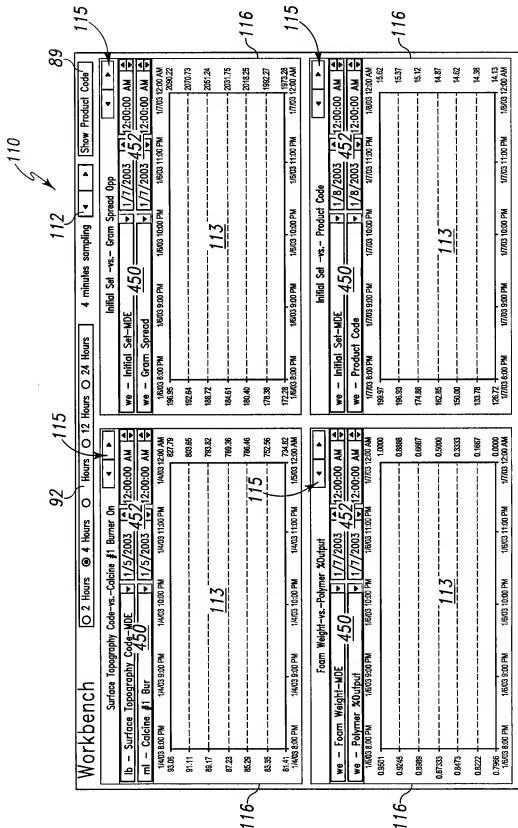
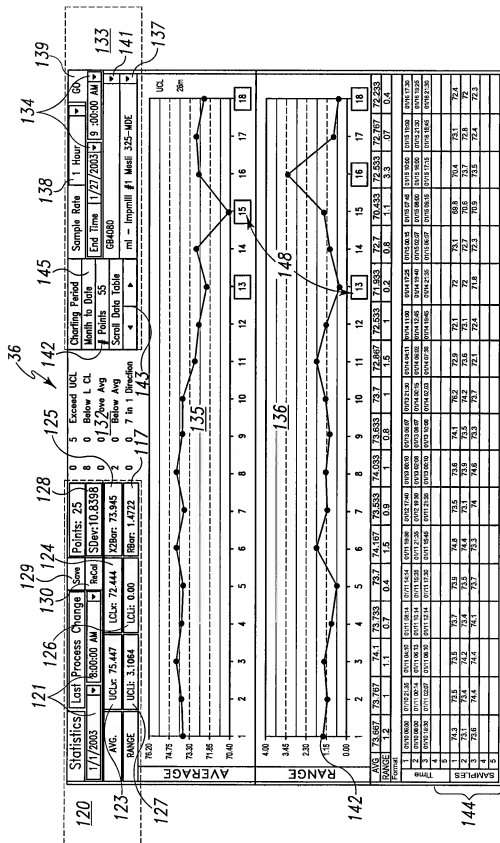


Fig. 8



150

SFC Reasons and Actions

152 ml - Impmill #1 Mesh 325-MDE

154 TimeStamp

156 Reason Code

158 Description

160 Corrective Active Code

162 Description

Previous Reasons/Actions

TimeStamp	Value	Reason Code	Description	Corrective Active Code	Description	Previous Reasons/Actions
1/7/03 9:11 AM	73.6					NONE
1/7/03 10:30 AM	73.7					NONE
1/7/03 12:30 AM	69.9					NONE
<p>You can type over the description for codes ending with 9999</p> <p>ML-0000 325 Mesh for Fine ML-0011 325 mesh too coarse ML-0012 325 mesh too coarse ML-9999 Other. You can type text over me</p>						
						NONE

168

169 Cancel

164 Best Practices Guide

167 Save

Use the dropdowns to select the Reason/Action Code from the valid list of codes.

Fig. 11A

150

SPC Reasons and Actions

152 ml - Impmill #1 Mesh 325-MDE

154 TimeStamp

156 Reason Code

158 Description

160 Corrective Active Code

162 Description

Previous Reasons/Actions

168

TimeStamp	Value	Reason Code	Description	Corrective Active Code	Description	Previous Reasons/Actions
1/14/03 5:23 PM	72					NONE
1/14/03 7:40 PM	72					NONE
1/14/03 8:35 PM	71.8					NONE
						NONE
						NONE

Previous Reasons

Previous Actions

475

Close

ML-9999-1: This is a test for MDE SPC 3/5/2003 8:33:17 AM

ML-9999: This is a test for MDE SPC 3/5/2003 8:33:17 AM

Cancel

Best Practices Guide

Save

Fig. 11B

The goal of this SOP is to produce stucco that is calcined below theoretical with as few adjustments as possible.

BEST PRACTICE/S.O.P.

166

1. Combined water of stucco exceeds the upper limit.

Make sure the grinds are in the reasonable limits.

(Course grounds will cause the moistures to go up)

Examine the history of previous moisture's.

(2 samples in a row high or most of the samples were high)

Examine the purity.

(If the purity went up quite a bit, the moisture's will get higher)

If the grinds are out of the control limits, they need to be lined out before any adjustments are made to the calcidyne's.

If grinds are in the control limits and purity is stable and sample still exceeds the upper limits then an adjustment to the calcidyne needs to be made.

When the purity goes up, it may take some time for the calcidyne's to adjust, no need to make adjustments right away. Run a couple of samples and see if they will adjust by themselves. If not make an adjustment.

2. Combined water of stucco is less than the lower limit.

Make sure the grinds are in the reasonable limits.

(Fine grinds will cause the moistures to go down)

Examine the history of previous moisture's.

(2 samples in a row low or most of the samples were low)

Examine the purity.

(If the purity went down quite a bit, the moisture's will get lower.

If the grinds are out of the control limits, they need to be lined out before any adjustments are made to the calcidyne's.

If grinds are in the control limits and purity is stable and sample still exceeds the lower limits then an adjustment to the calcidyne needs to be made.

192

Quality Report Login Screen

194

Open File

189

Enter Password:

Required to Change Plant/Server

Enter Password

Required to Activate the Open File Button, if a Corporate User.

195

Select Plant:

Apollo Beach

197

Select Server:

Select Plant Only if you are at the plant.

Corporate

Select Corporate only if you are located in Charlotte, or you need to access a plant server other than your own.

199

The Selected Server Is

HQADC

Fig. 13

193

MONTHLY BOARD QUALITY REPORT

Select Plant and Date for Report 195

Selected Plants:
 Select Month & Year:
 Start Date:
 End Date:

198

Data must be retrieved before you view Product Details or Reports

206

Review and Update product information

Select Products To Include In This Report

Product 1:
 Product 2:
 Product 3:
 Product 4:
 Product 5:

187

Server In Use: 199 HQADC

View Product Detail

Product 1 Detail
 Product 2 Detail
 Product 3 Detail
 Product 4 Detail
 Product 5 Detail

210

View/Print Reports

Monthly Board Report
 Monthly Board Weight Report
 Monthly Mill Report

213

215

Selected Server: 197 Corporate

Fig. 14

MONTHLY BOARD QUALITY REPORT

PRODUCT CODE AND DESCRIPTION	401		401		401		401		401	
	GB4080	GB9950	GB2280	GB0019	GB0116	1/2" REG TE	5/8" FS TE	1/2" KK TE	1/2" HS TE	1/2" SS HS (Sto-Smooth)
Lab	NAIL PULL - lbs of force									
Number of samples	75	22	1	9	4					
Specification (Min)	80.0	90.0	80.0	80.0	80.0					
3-Month Rolling Average	71.4	84.8	82.1	70.6	70.9					
Standard Deviation	2.722	4.458		2.985	3.081					
Year-to-Date Average	71.4	84.8	82.1	70.6	70.9					
Prior Year Average	74.886	89.838	85.750	77.067	76.100					
Cpk	-1.049	-0.391		-1.046	-0.990					
Est. Defects per 1,000 Units	>500	500		>500	>500					
Cp	-1.049	-0.391		-1.046	-0.990					
Lab	CORE HARDNESS - lbs of force									
Number of samples	68	21	1	9	4					
Specification (Min)	15.0	15.0	15.0	15.0	15.0					
3-Month Rolling Average	17.1	17.50	19.3	17.1	16.3					
Standard Deviation	1.366	1.750		1.054	0.831					
Year-to-Date Average	17.1	17.5	19.3	17.1	16.3					
Prior Year Average	18.276	23.058	17.333	18.389	16.889					
Cpk	0.518	1.514		0.668	0.535					
Est. Defects per 1,000 Units	80	<1		40	80					
Cp	0.518	1.514		0.668	0.535					
Lab	EDGE HARDNESS - CODE - lbs of force									
Number of samples	67	21	1	8	4					
Specification (Min)	15.0	15.0	15.0	15.0	15.0					
3-Month Rolling Average	56.1	72.4	64.3	56.5	51.7					
Standard Deviation	4.725	8.285		6.644	7.193					
Year-to-Date Average	56.1	72.4	64.3	56.5	51.7					
Prior Year Average	42.430	64.194	55.000	43.845	47.000					
Cpk	2.900	2.061		2.080	1.703					
Est. Defects per 1,000 Units	<1	<1		<1	<1					
Cp	2.900	2.061		2.080	1.703					
Lab	EDGE HARDNESS - OPP CODE - lbs of force									
Number of samples	66	21	1	8	4					
Specification (Min)	15.0	15.0	15.0	15.0	15.0					
3-Month Rolling Average	62.1	75.0	79.3	57.7	62.7					
Standard Deviation	5.351	7.700		4.366	0.837					
Year-to-Date Average	62.1	75.0	79.3	57.7	62.7					
Prior Year Average	49.159	60.030	62.222	46.282	47.000					
Cpk	2.934	2.599		3.261	19.016					
Est. Defects per 1,000 Units	<1	<1		<1	<1					
Cp	2.934	2.599		3.261	19.016					
Lab	END HARDNESS - lbs of force									
Number of samples	69	21	1	9	4					
Specification (Min)	15.0	15.0	15.0	15.0	15.0					
3-Month Rolling Average	16.1	22.2	20.3	16.4	15.2					
Standard Deviation	1.385	1.793		0.961	0.638					
Year-to-Date Average	16.1	22.2	20.3	16.4	15.2					
Prior Year Average	17.829	22.528	18.000	18.028	16.889					
Cpk	0.255	1.336		0.488	0.087					
Est. Defects per 1,000 Units	500	<1		120	>500					
Cp	0.255	1.336		0.488	0.087					

Fig. 15

Return

Save As File

Monthly Board Weight Report

PLANT: Wilmington MONTH: February 2003

214 ↗

1/2" SHEATHING		MONTHLY WEIGHT DATA		
Board	AVG WEIGHT	STD DEV	# OF SAMPLES	
December 2002	1719	9	2	
January 2003	1713	16	6	
February 2003				
March 2003				
April 2003				
May 2003				
June 2003				
July 2003				
August 2003				
September 2003				
October 2003				
November 2003				
December 2003				
YTD AVERAGE	1713	16	6	

Fig. 16

208

Product Data				408				409		Return	
PLC Value	406	Description	Product Code	Width	STD Speed	STD Dry Weight	STD Water Loss	STD-20-Hr Humidified Bond	STD-20-Hr Humidified Bond	Go Live Date	
0	NO PRODUCT RUNNING		NONE	NA	NA	NA	NA	NA	NA	6/10/2012 12:00 AM	
1	3/8" TE		GB3900	48"							
2	1/2" TE		GB8000	48"							
3	1/2" KK		GB5620	48"							
4	1/2" FSG		GB6733	48"							
5	1/2" MR		GB3760	48"							
6	1/2" KK FS		GB1242	48"							
7	1/2" HS CEILING		GB0019	48"							
8	1/2" SS (STA SMOOTH)		GB6270	48"							
9	1/2" SHEATHING		GB8000	48"							
10	5/8" FS		GB9950	48"							
11	5/8" MR FS		GB1400	48"							
12	5/8" KK FS		GB1050	48"							
13	5/8" FS JS		GB9466	48"							
14											
15											
16											
17											
18											
19											
20											
21											
22											
23											

405

Fig. 17

212 → 431 → 430 → 44

Return	Machine Speed	Dry Weight	Wet Weight	Water Loss	Board Width	Taper Depth	Core Hardness	Edge Hardness	End Hardness	d Deflect	Face Up MO	Face Down
Save As File	1339	272	328	25	272	270	271	0	3	9	25	25
January 2, 2003	160.7	1714	25	801	48.00	0.056	0.056	30.2	18.2	0.17	51	81
Monthly Information												
Count												
January 1, 2003												
January 2, 2003												
January 3, 2003												
January 4, 2003												
January 5, 2003												
January 6, 2003												
January 7, 2003												
January 8, 2003												
January 9, 2003												
January 10, 2003												
January 11, 2003												
January 12, 2003												
January 13, 2003												
January 14, 2003												
January 15, 2003												
January 16, 2003												
January 17, 2003												
January 18, 2003												
January 19, 2003												
January 20, 2003												
January 21, 2003												
January 22, 2003												
January 23, 2003												
January 24, 2003												
January 25, 2003												
January 26, 2003												
January 27, 2003												
January 28, 2003												
January 29, 2003												
January 30, 2003												
January 31, 2003												

Fig. 18A

REPLACEMENT SHEET 22
 SERIAL NO. 10828/751
 TITLE: SYSTEM AND METHOD FOR PLANT MANAGEMENT
 INVENTORS: PRICE, et al.

	Machine Speed	Dry Weight	Wet Weight	Water Loss	Board Width	Code	Opp Code	Caliper	Nail Pull	Cone Hardness	Edge Hardness	End Hardness	d Deflected	Face Up MO	Face Down	F
February 2005																
3-Month Rolling Ave																
Average	180.8	420	2511	800	47.697	0.092	0.096	0.480	77.5	21.8	20.0	18.0	0.138	46	50	
Number of Samples	2931		44	585	507	588	585	49	3	0	3	0	28	49	48	
Std Dev	3.464	53.583	45.858	33.003	0.019	0.020	0.017	0.004	4.387	1.073	1.411	0.082	0.025	4.442	3.550	
Std Dev / 1.7321	2.009	31.807	28.533	18.490	0.009	0.011	0.010	0.002	2.533	0.819	1.362	0.509	0.014	2.684	2.050	
Code					48	0.090	0.090	0.515					28.398			
Opp					0.019	0.020	0.017	0.004	4.387	1.073	1.411	0.082	0.025	4.442	3.550	
Cal					0.115	0.048	1.176	1.940					2.610	28.398	1.037	1.688
Opp					3.230	0.217	0.222	0.828	-0.334	3.852	3.289	2.810	28.398	1.037	1.688	
Cal					0.115	0.117	0.222	0.828	-0.334	3.852	3.289	2.810	28.398	1.037	1.688	
Opp					1.673	0.583	0.690	2.359	-0.334	3.852	3.289	2.810	28.398	1.037	1.688	
3-Month Period Ending January	181.1	421	2512	798	48.00	0.096	0.096	0.480	77.5	21.8	20.0	18.0	0.138	46	50	
February	180.8		2511	800	48.00	0.092	0.096	0.480	77.5	21.8	20.0	18.0	0.138	46	50	
March	179.9		2517	807	48.00	0.098	0.097	0.481	77.5	21.2	20.2	18.2	0.137	51	51	
April	177.8		2507	835	48.00	0.093	0.092	0.480								
May																
June																
July																
August																
September																
October																
November																
December																

Fig. 18B

	Machine Speed	Dry Weight	Wet Weight	Water Loss	Board Width	Code	Opp Code	Caliper	Nail Pull	Cone Hardness	Edge Hardness	End Hardness	d Deflected	Face Up MO	Face Down	F
Current Year Info																
Year-to-date Ave	179.8	422	2517	807	48.00	0.096	0.097	0.481	77.1	21.2	20.2	19.2	0.137	51	51	
End of Year Ave	179.8		2517	807	48.00	0.096	0.097	0.481	77.1	21.2	20.2	19.2	0.137	51	51	
December (Last Year)	161.8	1411	2502	791	48.00	0.090	0.090	0.480	77.8	23.0	20.0	18.7	0.133	45	49	
January	160.7	1714	2515	801	48.00	0.096	0.098	0.480	77.1	21.2	20.2	19.2	0.137	51	51	
February	177.0		2507	835	48.00	0.093	0.092	0.480								
3-Month Period Ending January																
February																
March																
April																
May																
June																
July																
August																
September																
October																
November																
December																
Year-to-date Ave	176.1	422	2502	791	48.00	0.090	0.090	0.480	77.8	23.0	20.0	18.7	0.133	45	49	
End of Year Ave	176.1		2502	791	48.00	0.090	0.090	0.480	77.8	23.0	20.0	18.7	0.133	45	49	

Fig. 18C

Fig. 19

252

Select Starting Date and Time:

February 25, 2003 12:00 AM

255

Select Plant:

Apollo

253

Select Period/Frequency:

1 Day - Every 15 Minutes

256

Next

254

Previous

257

Select Measures:

258

Retrieve Data

259

Save To File

For Best Performance:
If you are at a plant, you should select Plant Server.
Likewise, if you are in Charlotte, you should select Corporate Server.

Corporate Server

260

261

DATA

Standard Deviation	Date / Time	Running or Down	WE Product Code	KF Product Code	DE Product Code	KF Weight	DE Weight	KF Width	DE Width	KF Caliper Average	DE Caliper Average	DE End Pre-Kin Dry-Size Back	LB Humidified Bond Ties 2' Hour
	2/25/03 7:00 AM	Running	7000										
	2/25/03 7:15 AM	Running	7000										
	2/25/03 7:30 AM	Running	7000										
	2/25/03 7:45 AM	Running	7000										
	2/25/03 8:00 AM	Running	7000										
	2/25/03 8:15 AM	Running	7000										
	2/25/03 8:30 AM	Running	7000										
	2/25/03 8:45 AM	Running	7000										
	2/25/03 9:00 AM	Running	7000										
	2/25/03 9:15 AM	Running	7000										
	2/25/03 9:30 AM	Running	7000										
	2/25/03 9:45 AM	Running	7000										
	2/25/03 10:00 AM	Running	7000										
	2/25/03 10:15 AM	Running	7000										
	2/25/03 10:30 AM	Running	7000										
	2/25/03 10:45 AM	Running	7000										
	2/25/03 11:00 AM	Running	7000										
	2/25/03 11:15 AM	Running	7000										
	2/25/03 11:30 AM	Running	7000										
	2/25/03 11:45 AM	Running	7000										
	2/25/03 12:00 PM	Running	7000										
	2/25/03 12:15 PM	Running	7000										
	2/25/03 12:30 PM	Running	7000										
	2/25/03 12:45 PM	Running	7000										
	2/25/03 1:00 PM	Running	7000										
	2/25/03 1:15 PM	Running	7000										
	2/25/03 1:30 PM	Running	7000										
	2/25/03 1:45 PM	Running	7000										
	2/25/03 2:00 PM	Running	7000										
	2/25/03 2:15 PM	Running	7000										
	2/25/03 2:30 PM	Running	7000										
	2/25/03 2:45 PM	Running	7000										
	2/25/03 3:00 PM	Running	7000										
	2/25/03 3:15 PM	Running	7000										
	2/25/03 3:30 PM	Running	7000										
	2/25/03 3:45 PM	Running	7000										
	2/25/03 4:00 PM	Running	7000										
	2/25/03 4:15 PM	Running	7000										
	2/25/03 4:30 PM	Running	7000										
	2/25/03 4:45 PM	Running	7000										
	2/25/03 5:00 PM	Running	7000										
	2/25/03 5:15 PM	Running	7000										
	2/25/03 5:30 PM	Running	7000										
	2/25/03 5:45 PM	Running	7000										
	2/25/03 6:00 PM	Running	7000										

REPLACEMENT SHEET 23

SERIAL NO.: 10828,751

TITLE: SYSTEM AND METHOD FOR PLANT MANAGEMENT

INVENTORS: PRICE, et al.

Running

Fig. 20A

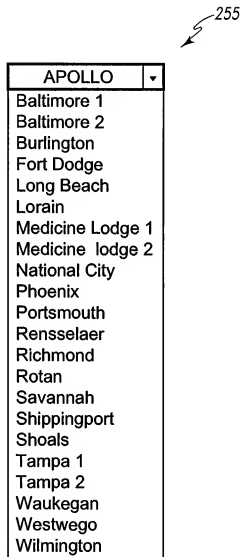


Fig. 20B

Select Period / Frequency

256

Select Period/Frequency:
1 Day - Every 15 Minutes
1 Day - Every 30 Minutes
1 Day - Every Hour
1 Day - Every 2 Hours
1 Week - Every 2 Hours
1 Week - Every 4 Hours
1 Week - Every 8 Hours
1 Week - Every 12 Hours
1 Month - Every 8 Hours
1 Month - Every 12 Hours
1 Month - Every Day

Fig. 20C

Select Server

257

Select Server
Corporate Server
Corporate Server
Plant Server

If you are at a plant, you should select Plant Server.
 Likewise, if you are in Charlotte, you should select Corporate Server.

Fig. 20D

Select Measures (Tags)

258

WE	KF	DE	KF	DE	KF	DE	KF
WE	Product Code						
WE	Product Code Test						
WE	Pulp %Output						
WE	Pulp Actual						
WE	Pulp Feed Tank Level Gals						
WE	Pulp Target						
WE	Pulper Batch Actual						
WE	Pulper Batch Potash Actual						
WE	Pulper Batch Potash Target						
WE	Pulper Batch Starch Actual						
WE	Pulper Batch Starch Target						
WE	Pulper Batch Target						
WE	Pulper Batch Time Remaining						
WE	Pulper Batch Time Target						
WE	Pulper Batch Waste Water Actual						

Caliper Average

Fig. 20E

Dry End Manual Data Entry																																					
Select Product Code																																					
Plant Line SHO 1		Product Code GB4080		Width 48"		Description 1/2" REG TE		Select Code Time 10:00		Dry Weight		Inches																									
Set Up		Select Product Code 10/12/002		313		311		Libs		Dry Scale Weight		Inches																									
Dry Width		Inches		Dry Scale Weight		Libs		Dry Weight		Inches		Inches																									
Board Caliper																																					
Code Edge		3"		6"		9"		12"		15"		18"		21"		24"		27"		30"		33"		36"		39"		42"		45"		48"		51"		Edge	
Edge Differential		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch		Thousands of an Inch	
Code Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth		Opposite Taper Depth	
Code Taper Width		Inches		Inches		Inches		Inches		Inches		Inches		Inches		Inches		Inches		Inches		Inches		Inches		Inches		Inches		Inches		Inches		Inches		Inches	
Code Edge Angle		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees		Degrees	
Code Edge Hardness		Avg		Avg		Avg		Avg		Avg		Avg		Avg		Avg		Avg		Avg		Avg		Avg		Avg		Avg		Avg		Avg		Avg		Avg	
Code Edge Hardness		Libs		Libs		Libs		Libs		Libs		Libs		Libs		Libs		Libs		Libs		Libs		Libs		Libs		Libs		Libs		Libs		Libs		Libs	
Moisture Profile																																					
Klin Drive Side					Opp Drive Side					Shear					End Peel																						
Code 6"					Code 6"					Code 6"					Code 6"																						
12"					12"					12"					12"																						
36"					36"					36"					36"																						
Opp 42"					Opp 42"					Opp 42"					Opp 42"																						
X					X					X					X																						
X					X					X					X																						
X					X					X					X																						
X					X					X					X																						
X					X					X																											

Fig. 21

Fig. 22

308

305

306

307

310

311

315

Mill Manual Data Entry

Select Date Time: 10/12/2002 10:00:00 AM

Plant: SHO

Set Up

Minimize

SPC Chart

View Mill Data

Accept

Rock F80	Purity <input type="text"/> %	Free Water <input type="text"/> %	Calcination <input type="text"/> %
Raymond Mill #1	100 Mesh <input type="text"/> %	325 Mesh <input type="text"/> %	Raymond Mill #2
Raymond Mill #3	<input type="text"/> %	<input type="text"/> %	Raymond Mill #4
Raymond Mill #5	<input type="text"/> %	<input type="text"/> %	Raymond Mill #6
Raymond Mill #7	<input type="text"/> %	<input type="text"/> %	Raymond Mill #8

Composite Land Plaster	Comb. H ₂ O <input type="text"/> %	Barry Calc. H ₂ O <input type="text"/> %	Purity <input type="text"/> %	Recy. Calcination <input type="text"/> %	100 Mesh <input type="text"/> %	325 Mesh <input type="text"/> %
Calcedine #1	Combined H ₂ O <input type="text"/> %	Calcedine #1	Combined H ₂ O <input type="text"/> %	Calcedine #3	Combined H ₂ O <input type="text"/> %	Calcedine #5
Calcedine #3	Combined H ₂ O <input type="text"/> %	Calcedine #3	Combined H ₂ O <input type="text"/> %	Calcedine #5	Combined H ₂ O <input type="text"/> %	Calcedine #7
Calcedine #5	Combined H ₂ O <input type="text"/> %	Calcedine #5	Combined H ₂ O <input type="text"/> %	Calcedine #7	Combined H ₂ O <input type="text"/> %	Calcedine #9

Composite Calcined Stucco	Combined Water <input type="text"/> %	Consistency <input type="text"/> %	Final Set <input type="text"/> %
Imp Mill #1	325 Mesh <input type="text"/> %	Imp Mill #2	325 Mesh <input type="text"/> %
Imp Mill #3	<input type="text"/> %	Imp Mill #4	<input type="text"/> %

Composite Imp Mill Stucco	Combined Water <input type="text"/> %	Consistency <input type="text"/> %	Final Set <input type="text"/> %
Imp Mill #1	325 Mesh <input type="text"/> %	Imp Mill #2	325 Mesh <input type="text"/> %
Imp Mill #3	<input type="text"/> %	Imp Mill #4	<input type="text"/> %

302

308

305

310

307

314

306

Wet End Manual Data Entry 312

Select Product: GB4080

Product Code: GB4080

Width: 48" Desc: 1/2" REG TE 313

Select Date & Time: 10/1/2002 10:00:00 AM 311

Print Page

Set Up

Minimize

SPC Chart

Board Profile

View Wet End Data

Accept

Cylinder Weight Code	X	grams	Gram Spread Code	X	grams
Cylinder Weight Field	X	grams	Gram Spread Opp	X	grams
Cylinder Weight Opp	X	grams			

Initial Set (TTU)	X	mm/ks	Field Set	X	mm/ks
Glimore (TTU) Set	X	mm/ks	Glimore 1# Final Set	X	mm/ks
Slump	X	inches			

Boot Temperature	X	%	Differential Boot-Head	X	%
Head Temperature	X	%			

Stucco Combined Water	X	%	Stucco Consistency	X	ml 100 grams
Foam Weight	X	mm/ks	H2O/Stucco Ratio	X	

315

Fig. 23

C:\Documents and Settings\iziesmi\Desktop\Nat Gypsum Local\Documentation-MDE.doc

Knife Manual Data Entry

303 →

Plant Line
 SHV 1

Set Up

Product Code
 GB4080

Width
 48"

Description
 1 1/2" REG TE

Select Product Code
 10712002

Select Time
 10:00

308

312

313

314

310

305

306

Minimize

SPC Chart

Board Profile

View Knife Data

Accept

Wet Width Inches

Wet Scale Weight Lbs

Wet Weight Lbs/MSF

Board Caliper

Opp Edge

3"

6"

9"

12"

15"

18"

21"

24"

27"

30"

33"

36"

39"

42"

45"

48"

51"

Average Field Caliper 48"

Thousands of an inch

Thousands of an inch

Thousands of an inch

Thousands of an inch

Edge Differential

Code Taper Depth

Code Taper Width

Code Edge Angle

Shoulder Differential

Opposite Taper Depth

Opposition Taper Within

Opposition Edge Angle

Thousands of an inch

Thousands of an inch

Inches

Degrees

Thousands of an inch

Inches

Degrees

Wet Band 1 to 5 with 5 Being Best

Face Wet Band

Back Wet Band

315

Fig. 24

304

312

LAB MANUAL DATA ENTRY

Select Product: GB4080
 Plant SHO Line 1 Width 48" Description 1/2" REG TE
 Select Date 10/1/2002 Select Time 10:00:00

SPC Chart
 Board Profile
 View Lab Data
 Set Up

Dry Weight	Weight	Lbs	Accept
Transverse Strength	Face Up/MD	Lbs	Face Down XMD
	Test 1	Lbs	Test 2
Nail Pull	Test 1	Lbs	Test 2
	Test 1	Lbs	Test 2
Core Hardness	Test 1	Lbs	Test 2
	Test 1	Lbs	Test 2
End Hardness	Test 1	Lbs	Test 2
	Test 1	Lbs	Test 2
Code Edge Hardness	Test 1	Lbs	Test 2
	Test 1	Lbs	Test 2
Opposite Edge Hardness	Test 1	Lbs	Test 2
	Test 1	Lbs	Test 2

310

315

Fig. 25